



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE-350DAMPER Job Sheet 189242



DAS
21
9-89

Part No: RBE-350DAMPER

Job Qty: 4 pcs

Part Name: Damper Spanner Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
95	Large Fab - Welded Assy-1	4 pcs	2/15/19		0.00	1.00	Large Fab - 1	JBC
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
100	QC 5	4 pcs	2/15/19		0.00	0.00	QC 5 - 10	JS
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 9 - 10	
							QC 9 - 18	
110	QC 9	4 pcs	2/15/19		0.00	0.00	QC 9 - 24	

ART
OSPACE

No: S152838



- 350DAMPER

89242

/Batch: S152838

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CANADA
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Date: 03/13/19

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Container No: S152838



Part: RBE-350DAMPER

Job No: 189242

Serial No/Batch: S152838

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 03/13/19

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				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
115	Handfinish -7-1-BeadBlast-B4B	4 pcs	2/15/19	0.00 1.00	Handfinish - 7 - 1 - B4B
120	Outsource - 12 - Black Oxide	4 pcs	2/15/19		GRO002-VC 10
125	Packaging 2-1 - Receive - B4B	4 pcs	2/15/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
126	QC 6	4 pcs	2/15/19	0.00 0.00	QC 6 - 38
					QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
130	Packaging 3-1 - Stock - B4B	4 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B

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					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
500	QC 21 - FG	4 pcs	2/15/19	0.00 0.00	QC 21 - FG - 21	21 MAR 19 2019
					QC 21 - FG - 70	21
Part Op 95 - (Weld per dwg A/R Steel rod Batch: _____), WELD AS PER DWG Descriptions: 100 - (QC5- Inspect part completeness to step on W/O) 110 - (QC9- Inspect visual per QSI004- Fusion Welds) 120 - -Issue P/O; PO <u>042306</u> -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 125 - (Receive & Inspect for Damage & Mat'l Certs) 126 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____), Identify and Stock 500 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
RBE-350DAMPER-03	Adjustable spanner	4 pcs (1 ea)	95-Large Fab - Welded Assy-1	5102443		
RBE-350DAMPER-05	Pin	8 pcs (2 ea)	95-Large Fab - Welded Assy-1	5102273		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
95-Large Fab - Welded Assy-1	RBE-350DAMPER-03	4	5	0		
	RBE-350DAMPER-05	8	10	0		
Part Specifications						
Specifications could not be found.						

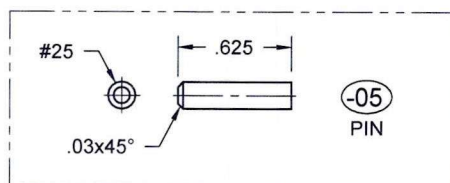
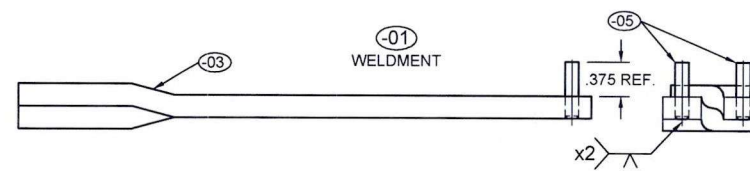
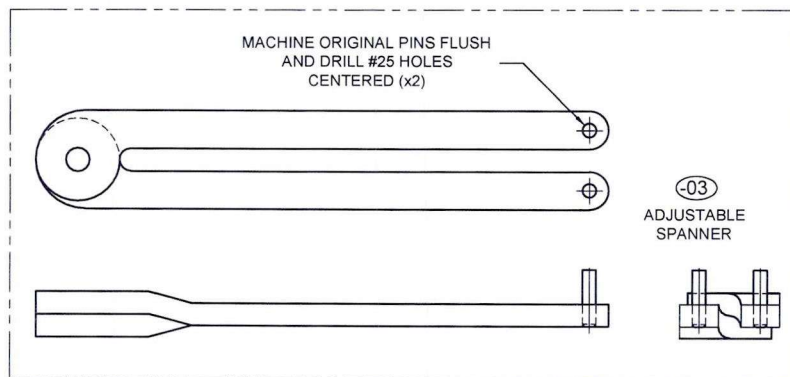
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/9/09	WP	DW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 189242415
1901-22



FUNCTION: USED TO REMOVE DAMPER CAP

 RED BARN MACHINE	
TITLE DAMPER SPANNER WRENCH	
DWG NO. RBE-350DAMPER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
DRAWN BY: PERRITT APPROVED: <i>D. Weil</i> HEAT TREAT: BLACK OXIDE FINISH SPEC: USED ON MODEL EUROCOPTER AS350/355	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-9-09
SHEET 1 of 1	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-01	1	WELDMENT		
	1	MACH	-03		ADJUSTABLE SPANNER	FORGED STEEL	MCMaster-CARR #5481A1
	2	MACH	-05		PIN	DRILL ROD	#25 MCMaster-CARR #3009A237
	ASSY -01						

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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AEROSPACE

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Container No: S152838



Part: RBE-350DAMPER

Job No: 189242

Serial No/Batch: S152838

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 02/12/19



Dart Aerospace Ltd.
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K6A 1K7
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PURCHASE ORDER PO042706



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042706
PO Date: 2/26/19
Due Date: 3/5/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189242	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	3/5/19	5 pcs	0 pcs	5 pcs	\$2.35/pcs	\$11.75
2	191018	RBEVR-L11-0010-002-D- 1	Rod -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/5/19	4 pcs	0 pcs	4 pcs	\$14.13/pcs	\$56.52

5 X MAR 13 2019

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PURCHASE ORDER

PO042706



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188149	RBE1X56-122-294-5	Threaded Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/5/19	6 pcs	0 pcs	6 pcs	\$2.35/pcs	\$14.10
4	190249	RBW6500X01611W142B-3T-1	Plate -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/5/19	4 pcs	0 pcs	4 pcs	\$5.71/pcs	\$22.84
5	189454	RBT18565-1	Hex Bit -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/5/19	10 pcs	0 pcs	10 pcs	\$1.10/pcs	\$11.00

6 X MAR 13 2019

4 X MAR 13 2019

10 X MAR 13 2019



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PURCHASE ORDER PO042706



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	188147	RBE1X56-122-294-1	Outside Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/5/19	5 pcs	0 pcs	5 pcs	\$4.71/pcs	\$23.55
7	191015	RBEVR-L11-0010-002-B-3	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/5/19	4 pcs	0 pcs	4 pcs	\$14.13/pcs	\$56.52

Grand Total: \$196.28



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PURCHASE ORDER PO042706



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/19 11:15 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017229- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Mar-2019		Shankar Anand		042706				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE-350DAMPER ✓ Rev.	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	5	5 ✓	0	0	DAS 68 9-89
2	RBEVR-L11-0010-002-D-1 ✓ Rev.	RBEVR-L11-0010-002-D-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4 ✓	0	0	0
3	RBE1X56-122-294-5 ✓ Rev.	RBE1X56-122-294-5 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OR OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	6	6 ✓	0	0	0
4	RBW6500X01611W142B-3T-1 ✓ Rev.	RBW6500X01611W142B-3T-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4 ✓	0	0	0
5	RBT18565-1 ✓ Rev.	RBT18565-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	10	10 ✓	0	0	0
6	RBE1X56-122-294-1 ✓ Rev.	RBE1X56-122-294-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5 ✓	0	0	0
7	RBEVR-L11-0010-002-B-3 ✓ Rev.	RBEVR-L11-0010-002-B-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4 ✓	0	0	0

0 1 7 2 2 9 - 1

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